






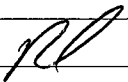
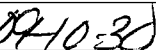


Work Order ID 53326

October 30, 2009 10:20:57 AM




Page 1

Item ID: D3443-041 Accept  Setup Start 
 Revision ID: C Stop 
 Item Name: Strut Weldment Assembly
 Start Date: 30/10/2009 Start Qty: 4.00  Cust Item ID:
 Required Date: 13/11/2009 Req'd Qty: 4.00  Customer:
 Reference:


Approvals: Process Plan:  Date:  Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								


100  Large Fab 0.00
 Large Fab Memo 0.00
 Large Fab Weld assembly as per dwg D3443

3

Cpl 09 11 09

110  QC9- Inspect visual per QSI004- Fusion Welds 0.00
 QC Memo 0.00
 Quality Control

FD 09.11.10 3

120  QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

3 

Work Order ID 53326

October 30, 2009 10:20:57 AM

Page 2

Item ID: D3443-041

Accept

Revision ID: C

Item Name: Strut Weldment Assembly

Start Date: 30/10/2009 Start Qty: 4.00

Required Date: 13/11/2009 Req'd Qty: 4.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M112148</i> Memo 1-Mask holes as per dwg D3443 START TIME: <i>7:00AM</i> OVEN TEMPERATURE: <i>400°F</i> FINISH TIME: <i>7:30AM</i>	0.00 <i>0.00</i>		<i>→ M 09/11/12</i>		<i>(X3)</i>	<i>0</i>		
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
150  Small Fab Small Fab	Small Fab Memo Assemble bearing and ball plungers as per dwg D3443 using DT9518 Ensure bearing rotates smoothly	0.00 0.00							

*09/11/12 (3)**09/11/12 (3)*

Work Order ID 53326

October 30, 2009 10:20:57 AM



Page 3

Item ID: D3443-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Strut Weldment Assembly

Start Date: 30/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Sp	09/11/12		3	6		
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>G.A</u> Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09/11/12 ③

09/11/12
MF
09-11-12

Picklist Print

October 30, 2009 10:21:01 AM

Page 1

Work Order ID: 53326

Parent Item: D3443-041RevC

Parent Item Name: Strut Weldment Assembly





Comments:

Start Date: 30/10/2009

Required Date: 13/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3443-1RevC 		Manufactured	No			100	Each	0.0000	4.0000	B51308 → ① *		
Lug D3443-5RevC 		Manufactured	No			100	Each	0.0000	4.0000	B46750 → ② *	Pl 09.11.10	
Tubing D3453-1RevB 		Manufactured	No			100	Each	10.0000	4.0000	B46751 → ③ *	Pl 09.11.10	
Clevis 										B42178 → ③ *	Pl 09.11.10	

Warehouse

Loc Qty



Loc Code

Location

Main Warehouse

st92

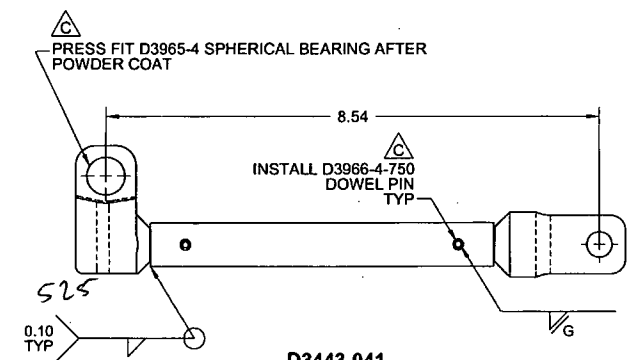
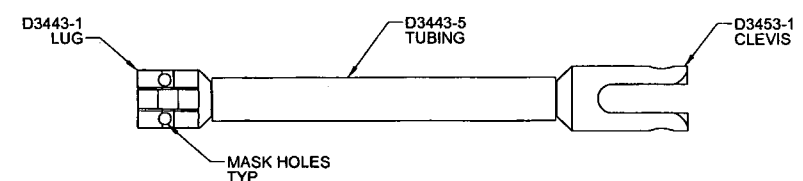
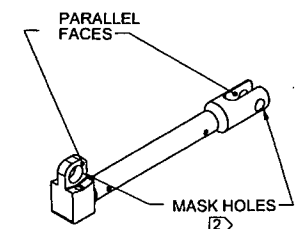
52986

D3965-4RevA 	Manufactured	No				100	Each	0.0000	4.0000	B53679 ③ *		
Bearing, Spherical D3966-4-750RevA 	Manufactured	No				100	Each	0.0000	8.0000			
Pin, Dowel												

Pl 09/11/12
Pl 09.11.10 *
B53631 → ⑥

PARTS NOT
SCANNED

8 7 6 5 4 3 2 1



D3443-041

ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

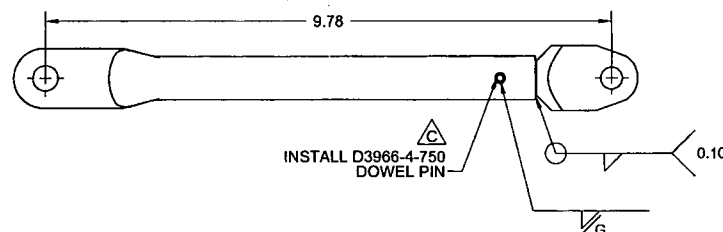
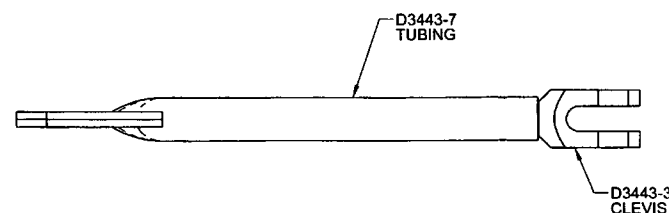
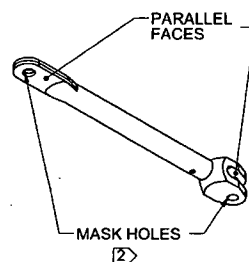
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 53324

RELEASED
9/16/25/MP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.33 lbs
 - 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN AB-1, AB-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3443	REV. C
MFG. APPR.	RF	SHEET 1 OF 4	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

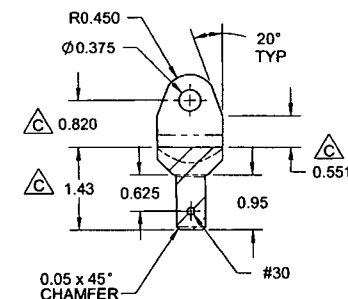
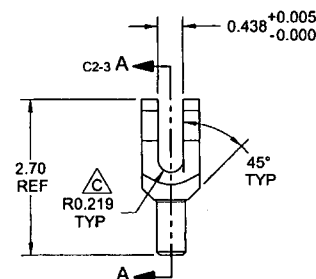
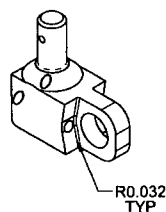
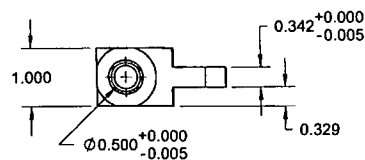
SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53324

RELEASED
09/06/25/14

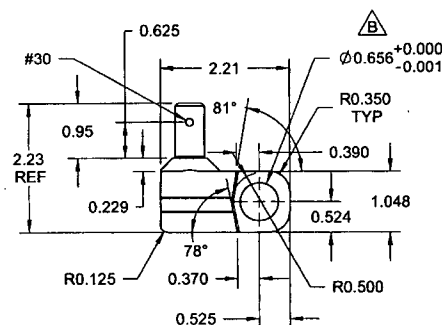
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

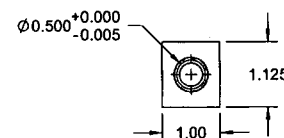
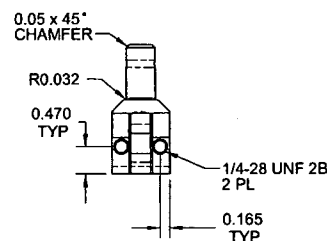
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A C4-3



D3443-1 LUG



D3443-3 CLEVIS

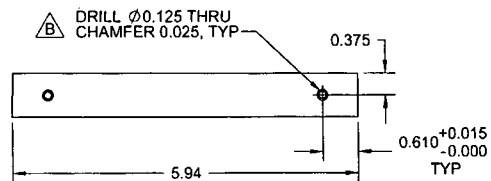
NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

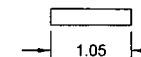
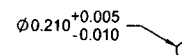
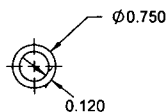
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53324

RELEASED
09/08/25/14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



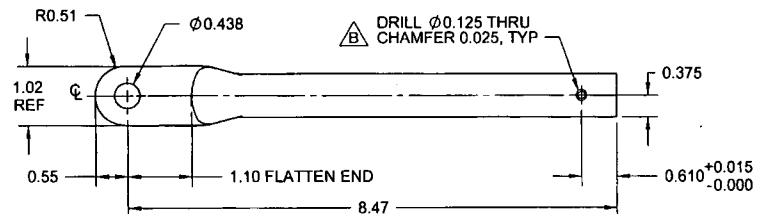
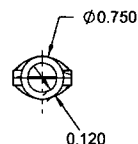
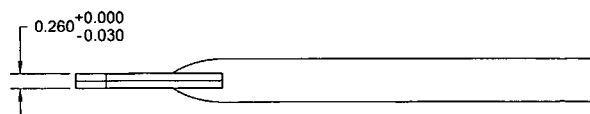
D3443-5 TUBING



D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING

D3443-5/7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

SHOP COPY
RETURNED TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT A REPAIR
WORK ORDER
NO. 53326

RELEASED
01/08/25 M2

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			